

Date: Thursday, 9/14/2006 7:27:50 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE, INBOARD, RS, 206
<b>Job Number</b> : 28551	
<b>Estimate Number</b> : 10821	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D26662
<b>This Issue</b> : 9/14/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2666 REV. C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 27111	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 9/30/2006 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JA 06.09.14</u>	
<b>Comment</b> : Est: C 06.11.01 Removed P/O for Powder Coat - in house processEC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101001	7075-T7351 2X6X6.25
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: B25344

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

3-Fixturing Inspection last completed on \_\_\_\_\_ by \_\_\_\_\_

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Debur

06.09.19 JA/JL 06/09/23

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

JL 06/09/22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

06.09.19 JA/JL 06/09/23

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *D*   Date:   06/10/11  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/14/2006 7:27:50 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 28551

Part Number: D26662

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*BF 06-09-23*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*YF*

*06/10/05 x 12*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*9.m 06/10/10*

*(12)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*06/10/11 (12)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5471*

*06/10/11 (12)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



*(12)*

Comment: FINAL INSPECTION/W/O RELEASE

*06/10/11*

Job Completion



*06/10/11*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28551
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2666-2
<b>Inspection Dwg:</b> D2666 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.123	.123	.123	.123		
B	0.100	0.140		.122	.122	.121	.122		
C	2.470	2.510		2.495	2.495	2.495	2.495		
D	0.100	0.180		.145	.145	.145	.145		
E	0.210	0.230		.222	.221	.221	.222		
F	1.313	1.343		1.328	1.327	1.327	1.327		
G	0.240	0.260		.254	.253	.253	.254		
H	0.615	0.685		.660	.660	.660	.660		
I	1.125	1.145		1.135	1.135	1.135	1.135		
J	0.990	1.010		1.001	1.001	1.001	1.002		
K	0.235	0.240		.237	.237	.237	.238		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.117	.117	.115	.118		
N	1.565	1.585	<del>DT8694B</del>						DT888
O	5.990	6.010		6.000	6.003	6.002	6.003		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.491	.501	.501	.500		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.499	2.500	2.500	2.499		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.550	.551	.551	.551		
X	1.674	1.684		1.679	1.679	1.679	1.678		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	06/09/16

Audited by:	RG
Date:	06.09.23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28551
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2666-2
<b>Inspection Dwg:</b> D2666 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122	.123	.122	.121		
B	0.100	0.140		.123	.124	.122	.123		
C	2.470	2.510		2.495	2.495	2.495	2.495		
D	0.100	0.180		.145	.145	.145	.145		
E	0.210	0.230		.221	.222	.221	.222		
F	1.313	1.343		1.328	1.328	1.325	1.323		
G	0.240	0.260		.253	.253	.250	.250		
H	0.615	0.685		.660	.660	.660	.660		
I	1.125	1.145		1.136	1.135	1.134	1.134		
J	0.990	1.010		1.000	1.001	1.001	1.001		
K	0.235	0.240		.238	.238	.237	.236		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.116	.118	.117	.116		
N	1.565	1.585	DT8888						
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.498	.497	.498	.496		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.361	1.362	1.362	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.550	.551	.548	.548		
X	1.674	1.684		1.679	1.678	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	3L / SD
Date:	06/09/17 / 06.09.19

Audited by:	RG
Date:	06.09.23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28551
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2666-2
<b>Inspection Dwg:</b> D2666 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.122	.121	.122		
B	0.100	0.140		.124	.122	.123	.124		
C	2.470	2.510		2.493	2.493	2.493	2.493		
D	0.100	0.180		.145	.145	.145	.145		
E	0.210	0.230		.222	.223	.224	.222		
F	1.313	1.343							
G	0.240	0.260		.251	.250	.251	.250		
H	0.615	0.685		.660	.660	.660	.660		
I	1.125	1.145		1.136	1.134	1.134	1.134		
J	0.990	1.010		1.002	1.001	1.001	1.002		
K	0.235	0.240		.238	.238	.238	.238		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.117	.117	.117	.117		
N	1.565	1.585	DT 8888						
O	5.990	6.010		6.001	6.000	6.001	6.000		
P	1.245	1.255		1.256	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.495	.498	.496	.497		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.500	2.499	2.500	2.499		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.549	.549	.549	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

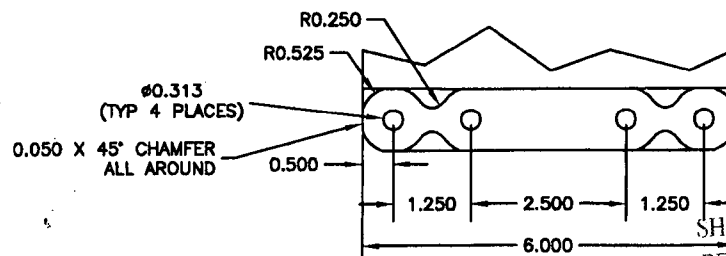
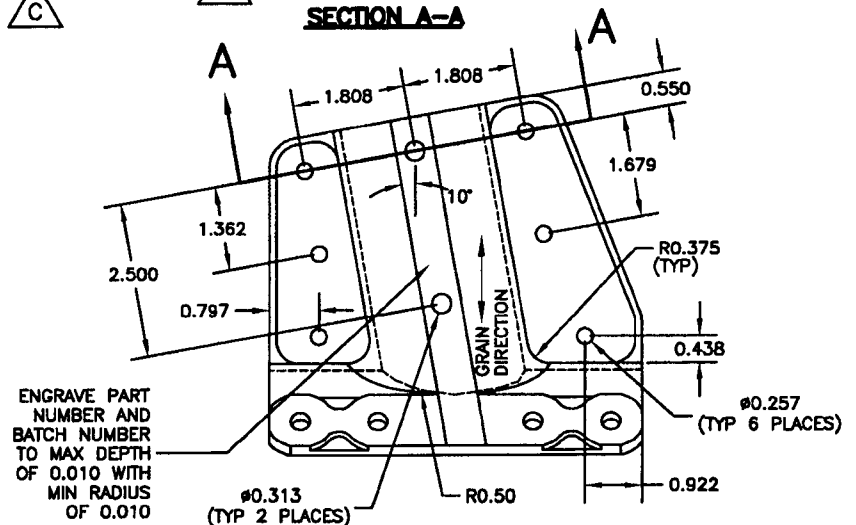
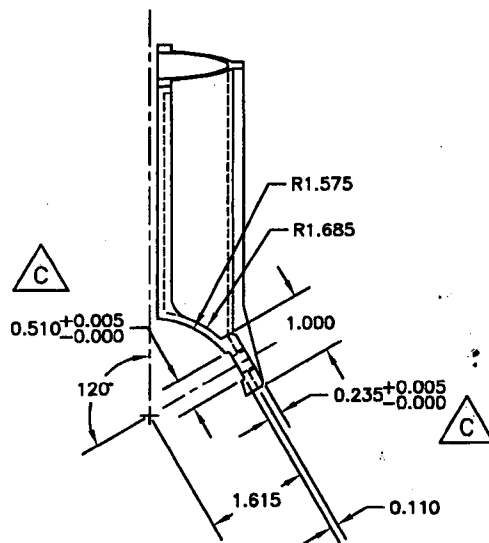
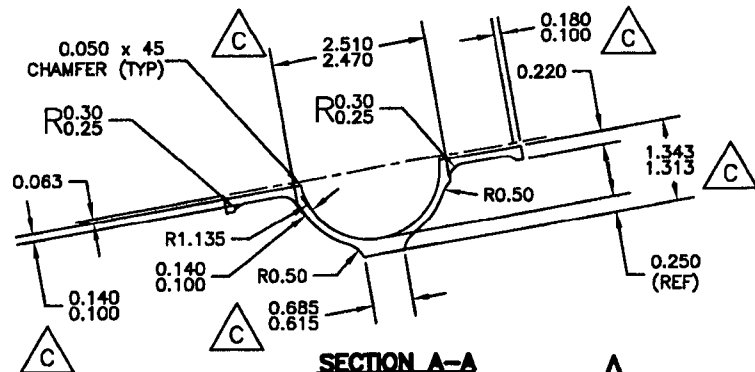
Measured by: SA
Date: 06.09.19

Audited by: RG
Date: 06.09.23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

**DART****RELEASED**  
de. de. 28

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2666	SHEET 1 OF 1
DATE		TITLE	SCALE
06.05.26		SADDLE FWD INSIDE HIGH	1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	

**D2666-1 SADDLE FWD INSIDE HIGH****NOTES:**

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28551

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